

Date: Wednesday, 18/06/2008 1:27:03 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DRIVE SHAFT TUNNEL
 Job Number : 39926-2
 Estimate Number : 13044
 P.O. Number :
 This Issue : 18/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3648041
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : D3648 REV.B
 Previous Run : 36910 Project Number : N/A
 Material : B
 Due Date : 07/07/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 08.6.18
 Comment : Est Rev:A New Issue 07-10-03 EC verified by: DD
 Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC
 Est Rev:C ECN1162 08-04-02 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D3649041 Tunnel Bottom Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 TUNNEL ASSEMBLY, BOTTOM PANEL
 batch: 39929

FF 08-07-30 (2)

3.0 D3650041 Tunnel Top Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 WELDMENT ASSEMBLY, TOP PANEL
 batch: 39930

FF 08-08-05 (2)

4.0 D3651041 Aft Base Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 AFT BASE ASSEMBLY
 batch: 39931

FF 08-07-30 (2)

5.0 AN3C3A Bolt



Comment: Qty.: 40.0000 Each(s)/Unit Total : 80.0000 Each(s)
 Bolt
 batch: 108473

08/07/29 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVE SHAFT TUNNEL

Job Number: 39926

Part Number: D3648041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 40.0000 EACH(s)/Unit Total : 80.0000 EACH(s)

WASHER

batch: 17108473

08/07/29

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3648

2- Seal mating surface and all gaps as per dwg D3648 with

Proseal 700 fire wall sealant

batch: 07108709

FF 08-08-05

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/06 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

1710839926

08/08/06 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/08

Job Completion



08.08.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN3C-3A BOI
AN960C10 WASHE
(14 PLA

1
NO SEALANT BE
THESE FLAT SU



DESCRIPTION
DRIVE SHAFT TUNNEL ASSEMBLY
TUNNEL BOTTOM PANEL ASSEMBLY
TUNNEL TOP PANEL ASSEMBLY
AFT BASE ASSEMBLY
BOLT
WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39926

RELEASED
08.03.27

D D3650-041	RF	08.01.07
	RF	07.11.07
	BY	DATE

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

REV. B

D3648

SHEET 1 OF 1

TITLE

SCALE

DRIVE SHAFT TUNNEL ASSY

1:6

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NOTES:

- 1) SEAL MATING SURFACES AND ALL OTHER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UN
- 4) UNITS: INCHES UNLESS OTHERWISE
- 5) BREAK SHARP EDGES: 0.005 TO 0.01
- 6) IDENTIFICATION: IDENTIFY WITH DART
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs

